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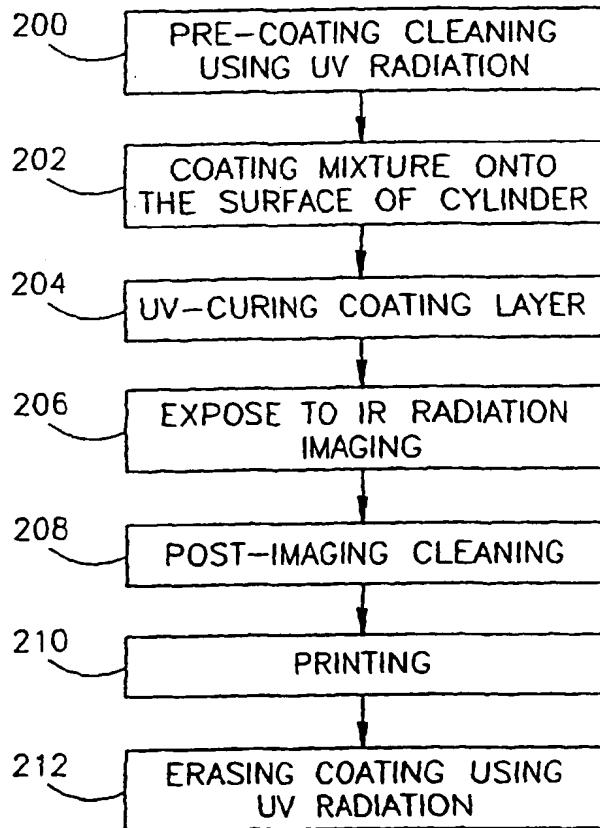
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[Continued on next page]

(54) Title: UTILIZING UV TO FORM AND DECOMPOSE A PRINTING MEMBER



(57) Abstract: In one embodiment, the present invention is directed to a method for preparing a printing member by coating a printing cylinder with a layer comprising ultraviolet-curable silicones and curing the layer using ultraviolet radiation.

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UTILIZING UV TO FORM AND DECOMPOSE A PRINTING MEMBER**BACKGROUND OF THE INVENTION**

Plateless imaging is a method of generating an image directly on a printing cylinder. The coating materials, which form the plateless printing member together with the cylinder surface, are applied on-press. The coating materials are applied in a liquid state and then cured. After each printing job, the cured materials are removed and the printing cylinder is prepared for reuse, either by cleaning the printing cylinder or by replacing a reusable substrate.

The use of cross-linked poly-dimethyl siloxane (PDMS) is well known in waterless offset printing. In existing plateless printing systems, the PDMS coating is cured by heating it to a temperature of approximately 120°C to 150°C. In order to prevent toning, the printing cylinder has to be cooled before printing to a temperature of approximately 20°C.

It would be desirable to use a coating that eliminates the need for heating the printing press.

BRIEF DESCRIPTION OF THE DRAWINGS

The subject matter regarded as the invention is particularly pointed out and distinctly claimed in the concluding portion of the specification. The invention, however, both as to organization and method of operation, together with objects, features and 5 advantages thereof, may best be understood by reference to the following detailed description when read with the accompanying drawings in which:

Fig. 1 is a schematic illustration of a plateless printing system according to some embodiments of the present invention;

Fig. 2 is a flow chart diagram of the operation of the system of Fig. 1 according to 10 some embodiments of the present invention;

Fig. 3 is a cross-sectional schematic illustration of a two-coat printing member according to some embodiments of the present invention;

Fig. 4 is a flow chart diagram of the operation of the system of Fig. 1 according to some embodiments of the present invention; and

15 Fig. 5 is a flow chart diagram of the operation of the system of Fig. 1 according to some embodiments of the present invention.

It will be appreciated that for simplicity and clarity of illustration, elements shown in the figures have not necessarily been drawn to scale. For example, the dimensions of some of the elements may be exaggerated relative to other elements for clarity. Further, 20 where considered appropriate, reference numerals may be repeated among the figures to indicate corresponding or analogous elements.

DETAILED DESCRIPTION OF THE PRESENT INVENTION

In the following detailed description, numerous specific details are set forth in order to provide a thorough understanding of the invention. However, it will be understood by those of ordinary skill in the art that the present invention may be practiced without these specific details. In other instances, well-known methods, procedures, components and circuits have not been described in detail so as not to obscure the present invention.

Various embodiments of the present invention are directed to utilizing ultraviolet (UV) or visible radiation to form and decompose a printing member for waterless offset printing. In these embodiments the imaging layer may comprise UV/visible-curable silicones, which are cross-linking poly-dimethyl siloxane (PDMS) having the ability of being cured by UV or visible radiation.

In some embodiments, which will be described hereinbelow with respect to Fig. 2, a single ablative imaging layer comprising UV-curable silicones is formed. A formulation comprising UV-curable silicones may be coated onto a printing cylinder having an ink-accepting oleophilic surface. The coated layer may be cured by UV radiation and then may be imaged by selectively ablating the cured layer, thus revealing the ink-accepting imaged areas.

In other embodiments, which will be described hereinbelow with respect to Figs. 3 and 4, a two-coat ablative imaging layer comprising UV-curable silicones is formed. In these embodiments, the cured bottom layer may serve as an ink-accepting agent.

In further embodiments, which will be described herein below with respect to Fig. 5, the imaging layer comprising UV/visible-curable silicones may allow direct imaging. In the direct imaging method, a suitable light source may be used to perform selective

UV/visible-curing of the silicone formulation. Non-limiting examples of such a light source include a laser having a suitable wavelength and a broadband light source having a suitable filter and a spatial light modulator (SLM). The formulation may be coated onto a printing cylinder having an ink-accepting oleophilic surface. The coated layer may be 5 selectively cured in the non-imaged areas. The uncured formulation may then be removed exposing the ink-accepting imaged areas.

Reference is now made to Fig. 1, which is a schematic illustration of a plateless printing system 10 according to some embodiments of the present invention. Printing system 10 may comprise a printing cylinder 12, a blanket cylinder 14, an inking system 16 10 and an imaging system 18.

Printing cylinder 12 may have an imaging layer, generally designated 100, directly coated onto cylinder 12. Alternatively, printing cylinder 12 may carry a replaceable substrate (not shown), either as a sleeve or as a sheet, that may be replaced after a large number of jobs. This has the advantage of protecting the cylinder from wear.

15 Printing system 10 may further comprise a coating system 20, a cleaning system 22 adapted to clean printing cylinder 12 after imaging and an erasing system 24 adapted to remove the ink leftover and the imaged layer after the printing impressions have been made. Coating system 20, cleaning system 22 and erasing system 24 may be any suitable system using any suitable process for coating, cleaning, and erasing, respectively.

20 Printing system 10 may comprise an UV curing system 25 having at least one UV lamp 26. UV lamp 26 may be adapted to move parallel to the longitudinal axis of cylinder 12 as it rotates, as indicated by arrows 30 and 32. Alternatively, the length of UV lamp 26 may be approximately the length of cylinder 12.

Printing cylinder 12 may comprise an oleophilic surface from a material that is suitable for receiving and adhesion of the oleophobic coating layer 100. Non-limiting examples of such a surface include plastics, reinforced plastics, metals such as aluminum (or anodized aluminum) and copper, ceramics and stones, such as granite.

5 Imaging layer 100 may comprise UV/visible-curable silicones such as UV 9500 of GE Bayer silicones, the Netherlands and SILCOLEASE UV POLY 200 of Rhodia Silicones, Lion, France. It has been found that in order to obtain good coating for a variety of substrates together with good adhesion to said substrates and good release properties of the layer formed and good scratch resistance, the following components of the coating may
10 be present in the following parts by weight:

UV-curable silicone	~50%-90%
Photo-initiator	~1%-10%
Photo-sensitizer	~1%-10%
Infrared absorber	~1%-20%

15 Vinyl ether such as those manufactured by BASF, Germany, by ISP, USA or by Morflex Inc. NC, USA may be added to the formulation described hereinabove. The properties of the coating formulation may be modified by vinyl ether monomers. The addition of vinyl ether to the above formulation may increase the adhesion of the layer to the surface, may reduce the viscosity of the formulation, and may improve flow properties.
20 Additionally, the incorporation of infrared (IR) absorbing materials, such as carbon black may be easier in a mixture comprising vinyl ethers.

Reference is now made to Fig. 2, which is a flow chart diagram of the operation of system 10 according to some embodiments of the present invention. Optionally, prior to coating, printing cylinder 12 may be irradiated using UV lamp 26 in order to clean its

surface (step 200). The UV radiation of the surface prior to coating may increase the adhesion of coating layer 100 to printing cylinder 12. Short UV radiation (either UVB or UVC) may activate certain surfaces by the oxidation of polymers having carbonyl and/or carboxyl groups, which are attached to the surface. As a result, the surface energy may be increased and the adhesion of the coating to the surface may be improved.

UV-curable silicones may have a long shelf life and/or pot life compared to other curable silicones used in existing printing systems. Therefore, the mixture for coating may be prepared off-press. The mixture may then be coated onto the surface of printing cylinder 12 using coating system 20 (step 202).

Next, UV lamp 26 may be turned on and may traverse the cylindrical surface as it rotates to allow the curing of layer 100 (step 204). Compared to other curing methods (e.g. heat energy), the use of UV and visible radiation for curing may be more efficient. The radiation may be directly focused on the surface with only relatively minor losses to the ambience. Additionally, UV lamps 26 may be turned on and off instantaneously and the duration of radiation may be shorter.

Imaging system 18 may then selectively expose the imaging layer during multiple rotations of printing cylinder 12 (step 206). During further rotations of cylinder 12, cleaning system 22 may be operated (step 208). At this stage, system 10 is ready to print and the appropriate ink may be applied to printing cylinder 12 by inking system 16. Printing cylinder 12 may be cooled if necessary to control the temperature of the ink during printing, for example in waterless printing. After the required number of impressions have been printed (step 210), the remainders of layer 100 and ink may be removed by erasing system 22 (step 212).

It is known that in the presence of UV radiation and nitrate (NO₃⁻) ions may decompose PDMS. In order to facilitate the post-printing cleaning, an aqueous solution comprising NO₃⁻ ions may be applied to the remainders of layer 100. UV lamp 26 may be turned on and cylinder 12 may be irradiated as it rotates to allow the decomposition of 5 the cured layer 100.

Reference is now made to Fig. 3, which is a cross-sectional schematic illustration of a two-coat imaging layer coated on a metal cylinder surface according to some embodiments of the present invention. Printing member 110 may comprise a metal surface 112, a first ink-accepting and heat-isolation layer 114, and a top IR ablateable oleophobic 10 layer 116.

First layer 114 may be of thickness between approximately 10-50 μ m and may comprise a radiation-curable resin or a heat-curable resin. Layer 114 may comprise UV-curable acrylates with a low resistance to aqueous solutions. Non-limiting examples of such acrylates include polyether acrylate, polyethylene glycol based acrylates and acrylates 15 with high acid value.

After curing, first layer 114 may be able to serve as an ink-accepting agent and as an isolating material for the IR imaging laser. It may eliminate the need for a polyester film and a clamping system to mount the film onto the cylinder. As a result, printing cylinder 12 may become a seamless cylinder having a printing member around its entire surface.

20 First layer 114 may be at least partially water-soluble or water sensitive and may be easily removed. Since no water is present during the waterless printing process, layer 114 may be removed in an easy and controlled manner. Top IR ablateable oleophobic layer 116 may be applied on top of cured layer 114 and may comprise the UV-curable silicone formulation described hereinabove in relation to Fig. 2.

Reference is now made to Fig. 4, which is a flow chart diagram of the operation of system 10 when applying the two-coat imaging layer on the printing cylinder according to some embodiments of the present invention. Optionally, prior to coating, printing cylinder 12 may be irradiated using UV lamp 26 for cleaning purposes (step 400). Then a 5 formulation comprising curable resin may be applied to the surface of cylinder 12 forming first layer 114 (step 402). First layer 114 may then be cured using UV lamp 26 (step 404). It should be noted that other curing methods like heat might be suitable for curing first layer 114.

A second formulation comprising UV-curable silicones is then applied on top of 10 layer 114 to form top layer 116 (step 406). Top layer 116 may be cured using UV lamp 26 (step 408). Imaging system 18 may then selectively expose the imaging layer during multiple rotations of printing cylinder 12 (step 408). During further rotation of cylinder 12, 15 cleaning system 22 may be operated (step 410). At this stage, system 10 is ready to print and the appropriate ink may be applied to printing cylinder 12 by inking system 16. After the required number of impressions have been printed (step 412), the remainders of layer 100 and ink may be removed by erasing system 22 (step 414).

It should be noted that some of the processes described hereinabove might be performed concurrently. For example, removing the remainders of the printed layer (step 20 414) and cleaning the cylinder with UV radiation before coating it for another printing job. Another example may be coating the cylinder while curing the coating layer. It should be noted that also more than two processes might be performed concurrently.

Reference is now made to Fig. 5, which is a flow chart diagram of a direct imaging operation of system 10 according to some embodiments of the present invention. The term direct imaging refers to selective hardening of the non-imaged area of the imaging layer. In

the method of ablation imaging described previously in relation to Fig. 2, the entire coating layer coated onto an ink-accepting substrate is first cured and then imaged by ablating, thus exposing the ink-accepting areas.

In contrast, in the method of direct imaging, only the non-imaged areas are 5 selectively cured by radiation from a suitable light source, which emits in the visible or UV region. Non-limiting examples of a suitable light source include a laser having a suitable wavelength and a broadband light source having a suitable filter and an SLM. The imaging layer may be coated onto a printing cylinder having an ink-accepting oleophilic surface. After selectively curing the imaging layer to form the non-imaged areas, the ink-accepting 10 imaged areas are exposed by removing the uncured formulation and exposing the cylinder. In these embodiments, the imaging system and the curing system are integrated, eliminating the need for two distinct units and speeding up the process of printing.

In the direct image process, printing cylinder 12 may be coated by a formulation comprising suitable photo-sensitizers and/or photo-initiators (step 500). Example II, which 15 is given below, describes a non-limiting example of such a formulation. The formulation may be applied directly onto the metal surface of cylinder 12, which may serve as the ink-accepting agent. Unlike the method of IR ablation, there is no need for thermal isolation achieved by a polyester film, therefore the printing member is mounted seamlessly on cylinder 12.

20 The non-image areas may be cured and imaged by a suitable radiation source (step 502). The uncured silicone, which is in a liquid state, is then removed (step 504). It should be noted that to remove the uncured silicone in this process is much easier than to remove the cured silicone in the ablation process. At this stage, system 10 is ready to print and the appropriate ink may be applied to printing cylinder 12 by inking system 16. After the

required number of impressions have been printed (step 506), the remainders of layer 100 and ink may be removed (step 508).

The following examples are now given, though by way of illustration only, to show certain aspects of some formulations according to some embodiments of the present 5 invention without limiting its scope.

Example I - Top ablative layer

This is an example illustrating the preparation of the formulation for a top IR ablative layer. The following formulation was prepared as a mixture (all numbers 10 designating parts in the formulation are in parts by weight of the entire formulation).

UV9400	(GE Bayer Silicones, the Netherlands)	76
<u>SILCOLEASE UV</u>	(Rhodia, Lion, France)	5
RCA 200		
SILQUEST A-186	(Witco, USA)	10
UV9380C	(GE Bayer Silicones, the Netherlands)	2
DAROCUR 1173	(Ciba-geigy, Switzerland)	1
SPEEDCURE-ITX	(Lambson Limited, UK)	1
SPECIAL BLACK 250	(Degussa, Germany)	5

The mixture was applied to a polymeric surface of a printing cylinder to a wet thickness of approximately 3μ and then was irradiated by UV lamp, which emits mainly in the UV region. The layer was then imaged with infrared imaging system.

Example II - Direct imaging layer

This is an example illustrating the production of the formulation for a direct imaging layer. The following formulation was prepared as a mixture (the percentages are by weight of the entire formulation).

5	<u>Name</u>	<u>Producer</u>	<u>%</u>
	Methylen chloride	Aldrich Sigma	50
	UV 9500	GE Bayer silicones	47
	UV 9380c	GE Bayer silicones	1.5
	Dye Green 471151	Aldrich-Sigma	1.5

10

While certain features of the invention have been illustrated and described herein, many modifications, substitutions, changes, and equivalents will now occur to those of ordinary skill in the art. It is, therefore, to be understood that the appended claims are 15 intended to cover all such modifications and changes as fall within the true spirit of the invention.

What is claimed is:

1. A method for preparing a printing member comprising:

coating a printing cylinder with layer comprising ultraviolet-curable silicones; and

5 curing said layer using ultraviolet radiation.

2. The method of claim 1, further comprising:

attaching an image bearing substrate to said printing cylinder, prior to
coating.

3. The method of claim 1, wherein said layer further comprises photo-initiators,

10 photo-sensitizers and infrared absorbing materials.

4. The method of claim 1, wherein said layer further comprises vinyl ethers.

5. A method comprising:

applying water and nitrate ions to a layer comprising cured silicones, said
layer coated onto a printing cylinder; and

15 irradiating said layer with ultraviolet radiation to decompose at least a
portion of said layer.

6. The method of claim 5 further comprising:

removing said at least partially decomposed layer from said printing
cylinder.

- 20 7. A method comprising:

coating a printing cylinder having a first layer thereon with a second layer
comprising ultraviolet-curable silicones and infrared absorbing materials; and

curing said second layer using ultraviolet radiation.

8. The method of claim 7, wherein said coating and said curing are performed in parallel.

9. The method of claim 7 further comprising:

curing said first layer prior to coating said second layer.

5 10. The method of claim 7, wherein said first layer is at least partially water-soluble.

11. The method of claim 7, wherein said first layer is water sensitive.

12. The method of claim 7, wherein said first layer comprise ultraviolet-curable acrylates with low resistance to aqueous solutions.

13. The method of claim 12, wherein said acrylates comprise polyether acrylates.

10 14. The method of claim 12, wherein said acrylates comprise polyethylene glycol.

15. The method of claim 12, wherein said acrylates comprise acrylates with high acid value.

16. The method of claim 7, wherein said second layer further comprises photo-initiators and photo-sensitizers.

15 17. The method of claim 7, wherein said second layer further comprises vinyl ethers.

18. A method comprising:

coating a cylinder surface with a layer comprising ultraviolet-curable silicones;

imaging said layer by applying any one of visible and ultraviolet radiation

20 to non-imaged areas thereon; and

removing said layer from imaged areas.

19. A method for promoting adhesion of a coating to a printing cylinder, wherein said coating is coated on-press, comprising :

irradiating said printing cylinder with ultraviolet radiation prior to said coating.

20. A printing member comprising:

a printing cylinder; and

5 an imaging layer coated on said printing cylinder, said imaging layer comprising ultraviolet-curable silicones.

21. The printing member of claim 20, wherein said printing member is configured such that after ultraviolet-curing and selective ablation of said imaging layer, selective areas of said imaging layer are removed thereby exposing said cylinder.

10 22. The printing member of claim 20, wherein said imaging layer further comprises photo-initiators, photo-sensitizers and infrared absorbers.

23. The printing member of claim 22, wherein said imaging layer further comprises vinyl ethers.

24. A printing member comprising:

15 a printing cylinder;

an image bearing substrate attached to said printing cylinder; and

an imaging layer coated on said substrate on-press, said imaging layer comprising ultraviolet-curable silicones.

25. The printing member of claim 24, wherein said printing cylinder is a seamless 20 machined cylinder.

26. The printing member of claim 24, wherein said printing member is configured such that after ultraviolet-curing and selective ablation of said imaging layer, selective areas of said imaging layer are removed thereby exposing said image bearing substrate.

27. The printing member of claim 24, wherein said imaging layer further comprises photo-initiators, photo-sensitizers and infrared absorbers.
28. The printing member of claim 27, wherein said imaging layer further comprises vinyl ethers.
- 5 29. A printing member comprising:
 - a printing cylinder;
 - a first layer coated thereon, said first layer comprising curable resin; and
 - an imaging layer coated on said first layer, said imaging layer comprising ultraviolet-curable silicones.
- 10 30. The printing member of claim 29, wherein said printing cylinder is a seamless machined cylinder.
31. The printing member of claim 29, wherein said printing member is configured such that after ultraviolet-curing and selective ablation of said imaging layer, selective areas of said imaging layer are removed thereby exposing said first layer.
- 15 32. The printing member of claim 29, wherein said imaging layer further comprising photo-initiators and photo-sensitizers.
33. The printing member of claim 32, wherein said imaging layer further comprising vinyl ethers.
- 20 34. The printing member of claim 29, wherein said first layer is at least partially water-soluble.
35. The printing member of claim 29, wherein said first layer is water sensitive.
36. The printing member of claim 29, wherein said curable resin comprises ultraviolet-curable acrylates having low resistance to aqueous solutions.

37. The printing member of claim 36, wherein said acrylates comprise polyether acrylates.

38. The printing member of claim 36, wherein said acrylates comprise polyethylene glycol.

5 39. The printing member of claim 36, wherein said acrylates comprise acrylates with high acid value.

40. A printing system comprising:

a printing member comprising an imaging layer having ultraviolet-curable silicones and coated on a printing cylinder or a replaceable substrate attached to 10 said printing cylinder;

an imaging system adapted to place an image on said printing cylinder or said substrate; and

an ultraviolet radiation system.

41. The printing system of claim 40, wherein said imaging system and said 15 ultraviolet radiation system are integrated into a single system.

42. The printing system of claim 40 further comprising an erasing unit adapted to remove at least a portion of said imaging layer.

43. The printing system of claim 40 further comprising a cleaning system adapted to clean said image placed on said printing member or said substrate.

20 44. The printing system of claim 40, wherein said printing member is configured such that after ultraviolet-curing and selective ablation of said imaging layer, selective areas of said imaging layer are removed thereby exposing said cylinder or said substrate.

45. The printing system of claim 40, wherein said imaging layer further comprises photo-initiators, photo-sensitizers and infrared absorbers.

46. The printing system of claim 45, wherein said imaging layer further comprises vinyl ethers.

5 47. A printing system comprising:

a printing member comprising a printing cylinder, a first layer coated thereon and an imaging layer coated on said first layer, said first layer comprising curable resin, said imaging layer comprising ultraviolet-curable silicones;

an imaging system adapted to place an image on said printing member;

10 and

an ultraviolet radiation system.

48. The printing system of claim 47 further comprising an erasing unit adapted to remove at least a portion of said printing member.

49. The printing system of claim 47 further comprising a cleaning system adapted to 15 clean said image placed on said printing member.

50. The printing system of claim 47, wherein said printing member is configured such that after ultraviolet-curing and selective ablation of said imaging layer, selective areas of said imaging layer are removed thereby exposing said first layer.

20 51. The printing system of claim 47, wherein said imaging layer further comprising photo-initiators and photo-sensitizers.

52. The printing system of claim 51, wherein said imaging layer further comprising vinyl ethers.

53. The printing system of claim 47, wherein said first layer is at least partially water-soluble.
54. The printing system of claim 47, wherein said first layer is water sensitive.
55. The printing system of claim 47, wherein said curable resin comprises ultraviolet-curable acrylates having low resistance to aqueous solutions.
56. The printing system of claim 55, wherein said acrylates comprise polyether acrylates.
57. The printing member of claim 55, wherein said acrylates comprise polyethylene glycol.
- 10 58. The printing member of claim 55, wherein said acrylates comprise acrylates with high acid value.
59. A formulation for a printing member, said formulation comprising a mixture including an ultraviolet-curable silicone, a photo-initiator, a photo-sensitizer and an infrared absorber.
- 15 60. The formulation of claim 59 further comprising vinyl ether.

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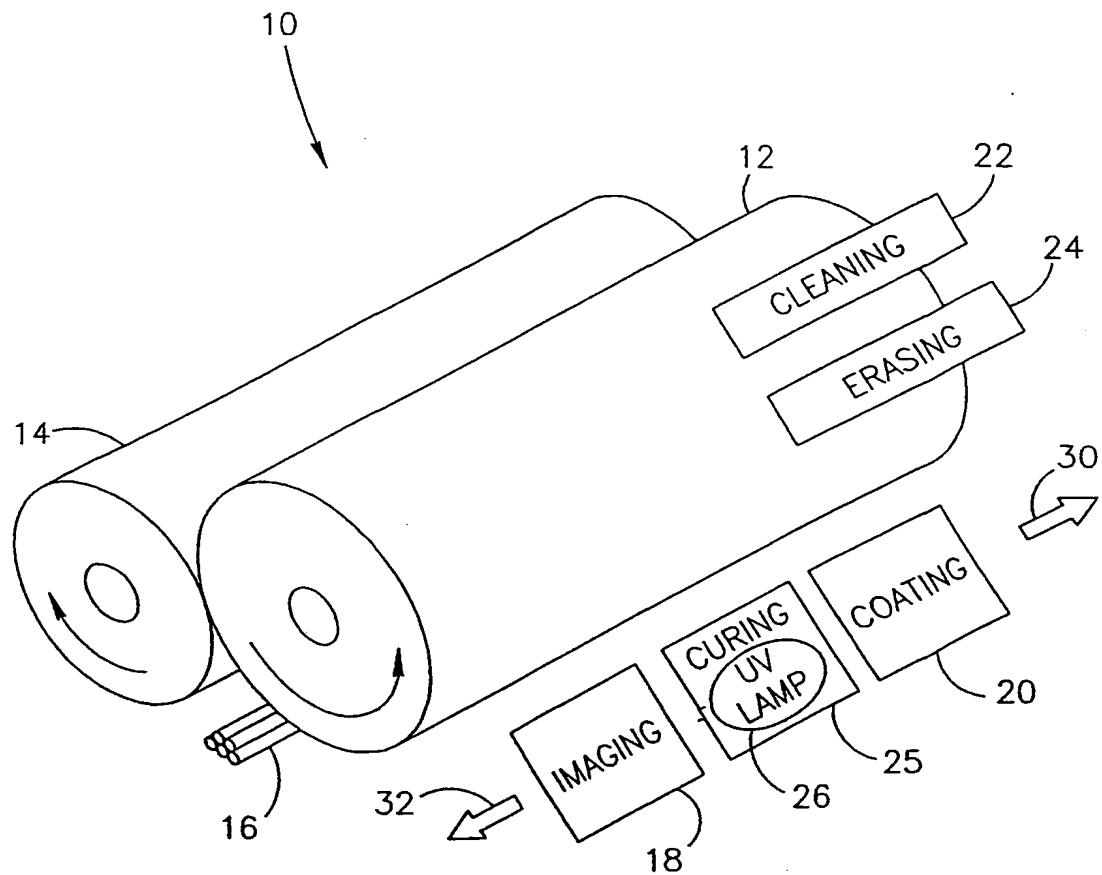


FIG.1

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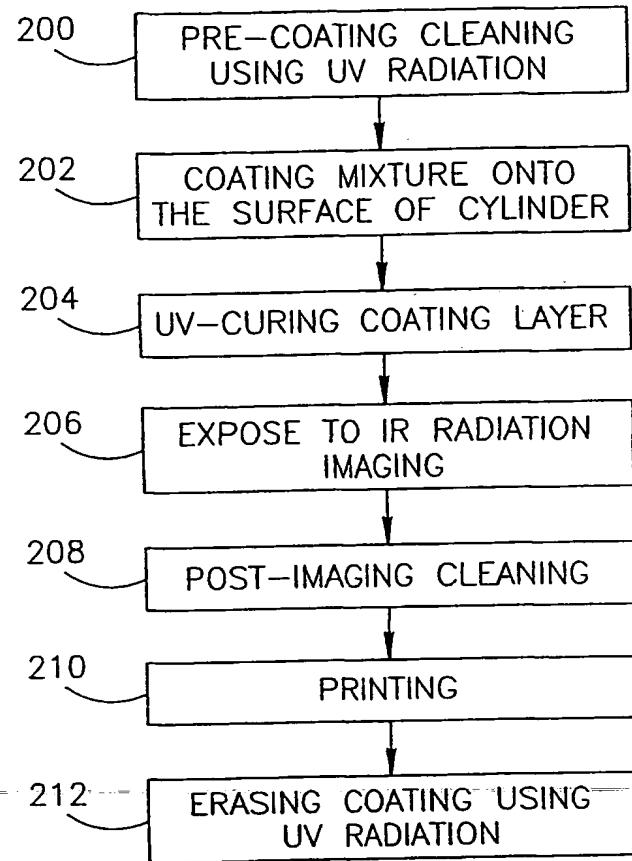


FIG.2

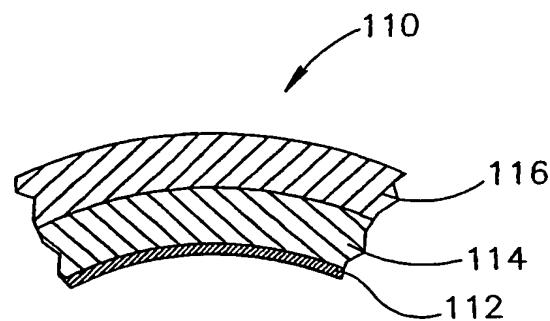


FIG.3

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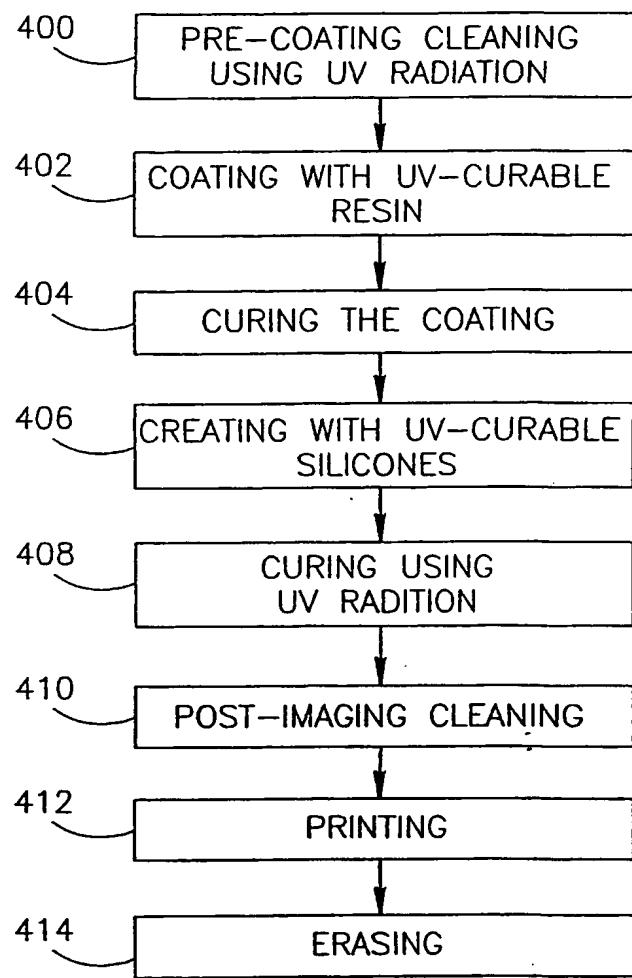


FIG.4

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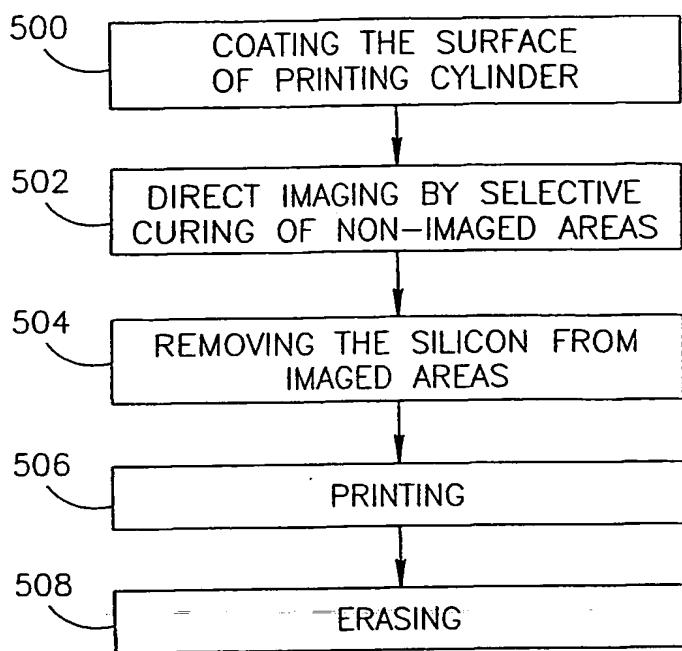


FIG.5

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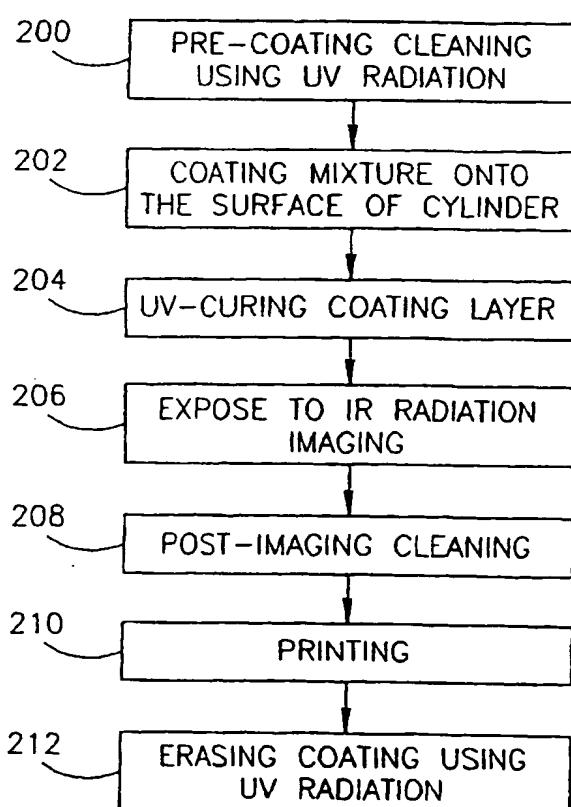
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[Continued on next page]

(54) Title: PREPARATION OF PRINTING CYLINDERS USING ULTRA-VIOLET RADIATION



(57) Abstract: In one embodiment, the present invention is directed to a method for preparing a printing member by coating a printing cylinder with a layer comprising ultraviolet-curable silicones and curing the layer using ultraviolet radiation.

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A. CLASSIFICATION OF SUBJECT MATTER

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According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B41C G03F B41N B05D C08K G03G C08G B41M

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

PAPERCHEM, PIRA, CHEM ABS Data, EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>EP 0 797 127 A (SHIN-ETSU POLYMER COMPANY LIMITED) 24 September 1997 (1997-09-24)</p> <p>page 3, line 45 -page 4, line 4 page 4, line 21 - line 25; figure 1A page 4, line 38 - line 55 claims 1-5; example 1 ----</p> <p style="text-align: center;">-/-</p>	1,3,4, 7-17, 19-23, 29-41, 45,46, 59,60

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

* Special categories of cited documents:

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T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

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Date of the actual completion of the international search

Date of mailing of the international search report

18 January 2002

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INTERNATIONAL SEARCH REPORT

International Application No

PCT/IL 01/00541

C(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 0 880 083 A (SHIN-ETSU POLYMER COMPANY LIMITED) 25 November 1998 (1998-11-25) page 2, line 53 -page 3, line 40 claims 1,8; examples 1-5 ---	1,3,4, 7-17, 19-23, 29-41, 45,46, 59,60
X	US 4 369 300 A (R.G.CARTER ET AL.) 18 January 1983 (1983-01-18) column 1, line 40 - line 45 column 3, line 12 - line 41 claim 1 ---	59,60
X	US 5-629 136 A (T.HIGASHI ET AL.) 13 May 1997 (1997-05-13) column 2, line 5 - line 56 column 3, line 56 -column 5, line 58 claim 1; examples 1-25 ---	59,60
A	DE 30 15 469 A (DAINIPPON PRINTING COMPANY LIMITED) 29 October 1981 (1981-10-29) claims 1-15; figures 1,2 page 5, line 1 - line 24 page 9, line 30 -page 10, line 15 ---	1-60

INTERNATIONAL SEARCH REPORT

Information on patent family members

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